



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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20NR-86
Job Sheet 191235



Part No: 20NR-86

Job Qty: 4 pcs

Part Name: Dual Hook Cage Frame



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/25/19

Job Tracking No:

Due Date: 5/10/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 20NR-86 Rev.1 IPP Rev. A 19.02.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Welded Assy-1	4 pcs	5/10/19		0.00	4.00	Large Fab - 1		2
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
115	QC 9	4 pcs	5/10/19		0.00	0.00	Large Fab - 9		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
120	QC 5	4 pcs	5/10/19		0.00	0.00	QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		



Container No: S176541



Part: 20NR-86

Job No: 191235

Serial No/Batch: S176541

Revision: 1

Inspector:

Exp Date:

Instructions:

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CANADA
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Date: 04/30/19

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130 Powdercoat - 6 Fire Red	4 pcs	5/10/19	0.00 0.00	QC 5 - 50	
				QC 5 - 30	
				Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
140 QC 3	4 pcs	5/10/19	0.00 0.00	Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
180 Packaging 3-1 - Stock - B4B	4 pcs	5/10/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	

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				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	4 pcs	5/10/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 110 - 1-Weld as per DWG. Use 8/20NR jig to assemble. 3/8" welds on all parts. See note 1 and 2.

Descriptions: 115 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

130 - Fire Red(Ref:4.3.5.10) per QSI005 4.3) Mask as per note 8. START TIME: _____ OVEN TEMPERATURE:

FINISH TIME: _____

140 - (QC3- Inspect Part Finish)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
20NR-119-1	Bracket	8 pcs (2 ea)	110-Large Fab - Welded Assy-1	5164305
20NR-119-10	Support Tubing	8 pcs (2 ea)	110-Large Fab - Welded Assy-1	5173610
20NR-119-2-DHC	DHC Back Plate	4 pcs (1 ea)	110-Large Fab - Welded Assy-1	5168407
20NR-119-3P	Feeder Support Bracket	16 pcs (4 ea)	110-Large Fab - Welded Assy-1	5029429
20NR-119-4	Left Top Feeder	8 pcs (2 ea)	110-Large Fab - Welded Assy-1	5168401
20NR-119-4B	Bottom Left Feeder	8 pcs (2 ea)	110-Large Fab - Welded Assy-1	5164329
20NR-119-5	Top Right Feeder	8 pcs (2 ea)	110-Large Fab - Welded Assy-1	5164382
20NR-119-5B	Bottom Right Feeder	8 pcs (2 ea)	110-Large Fab - Welded Assy-1	5164335
20NR-119-6	Upper Funnel Guide	16 pcs (4 ea)	110-Large Fab - Welded Assy-1	5168821
20NR-119-7	Lower Funnel Guide	16 pcs (4 ea)	110-Large Fab - Welded Assy-1	5170080
20NR-119-8	Front Support	16 pcs (4 ea)	110-Large Fab - Welded Assy-1	5164256
20NR-119-9-DHC	Guard	4 pcs (1 ea)	110-Large Fab - Welded Assy-1	5173554
20NR-120-5	Funnel Tab	8 pcs (2 ea)	110-Large Fab - Welded Assy-1	5164391

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	20NR-119-1	8	0	0
	20NR-119-10	8	0	0
	20NR-119-2-DHC	4	0	0
	20NR-119-3P	16 GA210F	13	0
	20NR-119-4	8	0	0
	20NR-119-4B	8	0	0
	20NR-119-5	8	0	0
	20NR-119-5B	8	0	0
	20NR-119-6	16	0	0
	20NR-119-7	16	0	0
	20NR-119-8	16	0	0
	20NR-119-9-DHC	4	0	0
	20NR-120-5	8	0	0

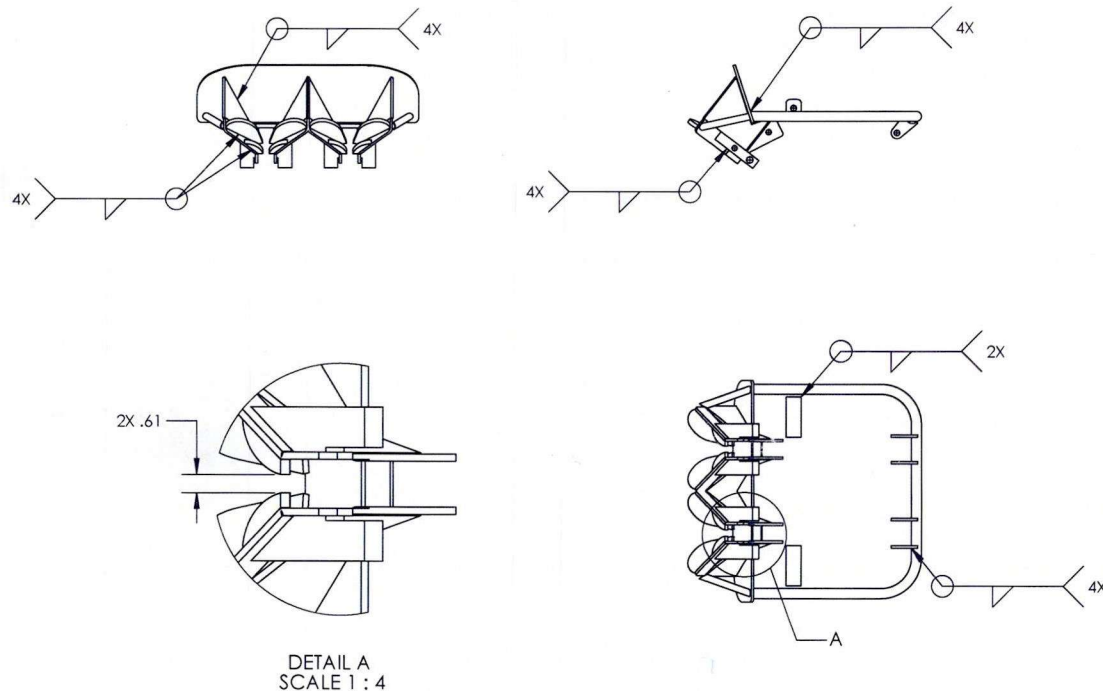
Part Specifications

Specifications could not be found.

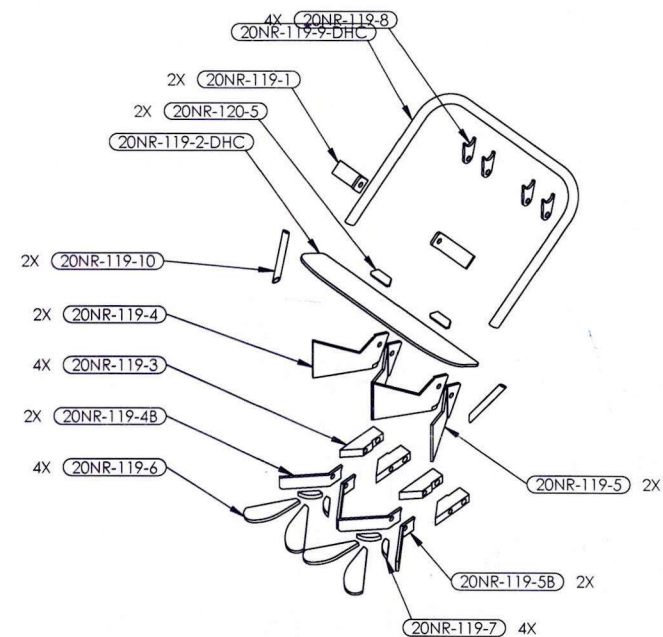
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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	AS DRAWN BY CANAM	10/8/2013	JAG	



DETAIL A
SCALE 1:4



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material
			20NR-119-1	2	BRACKET	A36
			20NR-119-2-DHC	1	DHC BACK PLATE	1018
			20NR-119-3	4	FEEDER SUPPORT BRACKET	1018
			20NR-119-4	2	LEFT TOP FEEDER	1018
			20NR-119-4B	2	BOTTOM LEFT FEEDER	1018
			20NR-119-5	2	TOP RIGHT FEEDER	1018
			20NR-119-5B	2	BOTTOM RIGHT FEEDER	1018
			20NR-119-6	4	UPPER FUNNEL GUIDE	4140
			20NR-119-7	4	LOWER FUNNEL GUIDE	1018
			20NR-119-8	4	FRONT SUPPORT	1018
			20NR-119-9-DHC	1	GUARD	1018/1026 CDS
			20NR-119-10	2	SUPPORT TUBING	1018/1026 CDS
			20NR-120-5	2	FUNNEL TAB	1018

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 191235 MJS
19-02-21

1. USE 8/20NR CAGE JIG TO ASSEMBLE
2. 3/8 WELDING TO ALL PARTS

RED BARN MACHINE	
DUAL HOOK CAGE	
DWG NO.	20NR-86
REV 1	
MATERIAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005	FRACTIONS ± 1/32
.XX ± .01	ANGLES ± 5°
.X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45°	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE	1:12
DATE	
SHEET 1 OF 1	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					